

# Work Order ID 43883

June 26, 2009 10:39:40 AM



Page 1

Item ID: D206-571-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Valve/Manifold Assembly

Start Date: 15/07/2009 Start Qty: ~~1.00~~ <sup>2</sup>



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: ME

Date: 09/09/24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D206-571	Rev C
----------	-------

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--



Packaging

Memo

0.00

Packaging

*20 8/9/04*  
*pur smy*

110	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg. D206-571, page 4

*7 m-k 09/11/04* **(2x)**

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC

Memo

0.00

Quality Control

*28 08/10/04*

**(2)**

# Work Order ID 43883

June 26, 2009 10:39:41 AM



Page 2

Item ID: D206-571-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Valve/Manifold Assembly

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start

# Picklist Print

Page 1

July 1, 2009 1:57:51 PM

Work Order ID: 43883

Parent Item: D206-571-043RevC

Parent Item Name: Valve/Manifold Assembly



Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2410RevA1  206 Aspirator Assembly		Manufactured	No			110	Each	0.0000	1.0000 		7/9/09 (2)	

Status	Item ID	Rev	Name	Start Date	Quantity	Pe	JO	mp	D	te	Sec	rap	Q	um	me	nd	NEC	IECX	ISort	ime	Offset	in	Ty	1	Per	O	ch	to	lore	Cie	Last	M
<input checked="" type="checkbox"/>	D2120		Tabwasher	01/01/08	1.0000	Ea			110	0	0.						0	0	MR												06/...	
<input checked="" type="checkbox"/>	AN816-8-8D		Nipple	01/01/08	1.0000	Ea			110	0	0.						0	0	MR												06/...	
<input checked="" type="checkbox"/>	MS20995-C20		Lockwire	01/01/08	0.5000	Ea			120	0	0.						0	0	MR	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>									06/...	
<input checked="" type="checkbox"/>	D2455	A	Noise Attenuater	01/01/08	1.0000	Ea			110	0	0.						0	0	MR	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>									06/...	
<input checked="" type="checkbox"/>	D2001-08	C	VALVE	01/01/08	1.0000	Ea			110	0	0.						0	0	MR	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>									06/...	
<input checked="" type="checkbox"/>	D2026-101	A	Capscrew 10-24 3/8lg St.	01/01/08	2.0000	Ea			110	0	0.						0	0	MR	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>									06/...	
<input checked="" type="checkbox"/>	D2160	B	Lever	01/01/08	1.0000	Ea			110	0	0.						0	0	MR	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>									06/...	
<input checked="" type="checkbox"/>	D2410	A1	206 Aspirator Assembly	01/01/08	1.0000	Ea			110	0	0.						0	0	MR	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>									06/...	

Date: Tuesday, 02/12/2008 11:16:56 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VALVE/MANIFOLD ASSEMBLY
Job Number	: 43883		
Estimate Number	: 10361		
P.O. Number	:	Part Number	: D206571043
This Issue	: 02/12/2008 S.O. No. :	Drawing Number	: D206-571 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 35304	Material	:
Written By	:	Due Date	: 22/12/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JLD 08.12.02</u>		
Comment	: Est Rev:B 01.08.28 Reformat SM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	✓	PACKAGING 1	PACKAGING RESOURCE #1
-----	---	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Pick Assembly Kit

2.0	✓	D200108	VALVE
-----	---	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch No.
1	D2001-08	Valve	310284

3.0	✓	D2026101	Capscrew 10-24 3/8lg St.
-----	---	----------	--------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch No.
2	D2026-101	Screw	35376

4.0	✓	D2120	Tabwasher
-----	---	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch No.
1	D2120	Tab Washer	2277

5.0	✓	D2160	Lever
-----	---	-------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch No.
			35887

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 02/12/2008 11:16:56 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE/MANIFOLD ASSEMBLY

Job Number: 43883

Part Number: D206571043

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2160 Lever

6.0



D2410

206 Aspirator Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2410	Aspirator Manifold	B 43939

NO QTY'S.

8 09/17/04

(2)

7.0



D2455

Noise Attenuator



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2455	Noise Attenuator	2455

88 09/03/13 (x12)

8.0



AN81688D

Nipple



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	AN816-8-8D	Nipple	2198

88 09/03/13 (x12)

9.0



MS20995C20

Lockwire



Comment: Qty.: 0.5000 f(s)/Unit Total : 0.5000 f(s)

Lockwire

PT16074

88 09/03/13 (x12)

10.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg. D206-571, page 4

M-1 09/11/04

(2X)

11.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/14/04

(2)

12.0



PACKAGING 1


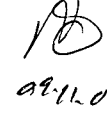
PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/11/04	10	need 2 washer AN9605D 10 to put under the screw D2026-101  AN9605D 10 M 112369  <u>Permanent change</u>	JB	09/11/04	4		 09.11.04

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 02/12/2008 11:16:56 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE/MANIFOLD ASSEMBLY

Job Number: 43883

Part Number: D206571043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0 ✓

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion ✓



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <b>B WILLIAMS</b>	DRAWN BY <b>K HAND</b>	<b>DART AEROSPACE LTD</b> VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>KH</i>	DRAWING NO. <b>D206-571</b>	REV. C SHEET 1 OF 11
DATE <b>JUNE 9, 1992</b>		TITLE <b>BELL 206 HEATING SYSTEM</b>	
<b>C</b>	<b>JUNE 30, 1995</b>	<b>RE-DRAWN</b>	

Part No.	Description	-011	-013	-043	-341	-345
D206-571-011	Heater Kit 206A/B/L	X				
D206-571-013	Heater Kit 206L1/L3/L4		X			
D206-571-043	Valve/Manifold Assembly	1	1	X	1	1
D206-571-341	Supplementary Heater Kit 206A/B				X	
D206-571-345	Supplementary Heater Kit 206L1/L3/L4					X
D2001-08	Valve			1		
D2003-041	Tube Assembly (8J)	1				
D2003-043	Tube Assembly (8J)	1				
D2005-001	Hose Assembly (8J)	1			1	1
D2005-009	Hose Assembly (8J)	1	2		1	1
D2005-011	Restrictor	1				
D2005-013	Restrictor	1				
D2007-001	Adapter		1			
D2026-101	Screw			2		
D2050	Grille	1	1		1	1
D2120	Tab Washer			1		
D2162-3R-096	Control Cable	1			1	
D2162-3R-120	Control Cable		1			1
D2155	Adapter, 2" - 3" Hose					
D2156	Vent Flange	1	1		1	1
D2160	Lever			1		
D2377	Flow Divider	1	1		1	1
D2410	Aspirator Manifold Assembly			1		
D2455	Noise Attenuator			1		
SCEET 12	Hose 3" dia	11'	11'		11'	11'
AN526-832R6	Screw	10	10		10	10
AN526-1032R12	Screw	6	10		6	10
AN804-8J	Bulkhead Tee Fitting	1	1		1	1
AN814-L8J	Cap, Male	1	1			
AN815-8J	Union	1	1			
AN816-8-8D	Nipple			1		
AN824-8J	Tee Fitting	1				
AN919-12D	Reducer					
AN924-8J	Nut	3	1		1	1
AN929-8J	Cap, Female	1	1			
AN938-8D	Tee, Female					
AN938-8J	Tee, Female	1				
AN960JD10	Washer	10	10		10	10
AN960JD8	Washer	10	10		10	10
AN960C1216	Washer	2	2		2	2
QS100-24S	Clamp					
QS100-48S	Clamp	8	8		8	8
MS9385-08	O'Ring	5	2			
MS21042L3	Nut (Option MS21042-3)	6	10		6	10
MS21042L08	Nut (Option MS21042-08)	10	10		10	10
MS21919DG6	Clamp, Cushion	6	10		6	10
NAS48DD3-24	Spacer	6	10		6	10
23007167	Gasket		1			

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WORK ORDER  
NO. 13883

**DART**

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CHECKED B.W.	APPROVED [Signature]	DRAWING NO. D206-571	REV. C SHEET 2 OF 11
DATE JUNE 9, 1992		TITLE BELL 206 HEATING SYSTEM	
C	JUNE 30, 1995	RE-DRAWN	

**GENERAL NOTES:****1. CAUTION**

ENSURE TUBING, FITTINGS, AND VALVES OF THIS SYSTEM CLEAR STRUCTURE, WIRING AND COMPONENTS BY A MINIMUM OF 0.25 INCH AND CLEAR CONTROLS BY A MINIMUM OF 0.40 INCH.

THIS CAN BE ACCOMPLISHED BY THE PROCEDURES OF THE DRAWINGS AND BY FOLLOWING THE STANDARD CLAMPING PRACTICES OF AC43.13.1A USING MS21919 CLAMPS (OR EQUIVALENT) OF AN APPROPRIATE SIZE.

**2. ON C208 AND C20R ENGINES**

REMOVE ANN814-8 PLUG OR PARTICLE SEPARATOR RESTRICTOR AND REPLACE WITH D2005-013 RESTRICTOR C/W AN939-8J, 'O' RING AND LOCKNUT AS SHOWN ON SHEET 8. REINSTALL AN814-8 OR PARTICLE SEPARATOR RESTRICTOR IN AN939-8J AS SHOWN ON SHEET 8.

**3. LOCKWIRE**

LOCKWIRE PER MS33540 USING MS20995C LOCKWIRE.

**4. COMPATIBILITY**

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE RESPONSIBILITY OF THE INSTALLER. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

**5. WORKMANSHIP**

UNLESS OTHERWISE STATED ALL WORKMANSHIP IS TO BE TO THE STANDARDS OF THE AIRCRAFT MAINTENANCE MANUAL AND AC 43.13.1A

**6. INSTALLATION INSTRUCTIONS**

THIS DRAWING IS TO BE USED IN CONJUNCTION WITH INSTALLATION INSTRUCTIONS IIN-D206-571.

**7. CONTINUING AIRWORTHINESS**

THIS INSTALLATION SHOULD BE MAINTAINED IN ACCORDANCE WITH MAINTENANCE MANUAL SUPPLEMENT MMS-D206-571.

**8. SUPPLEMENTARY HEATER KITS**

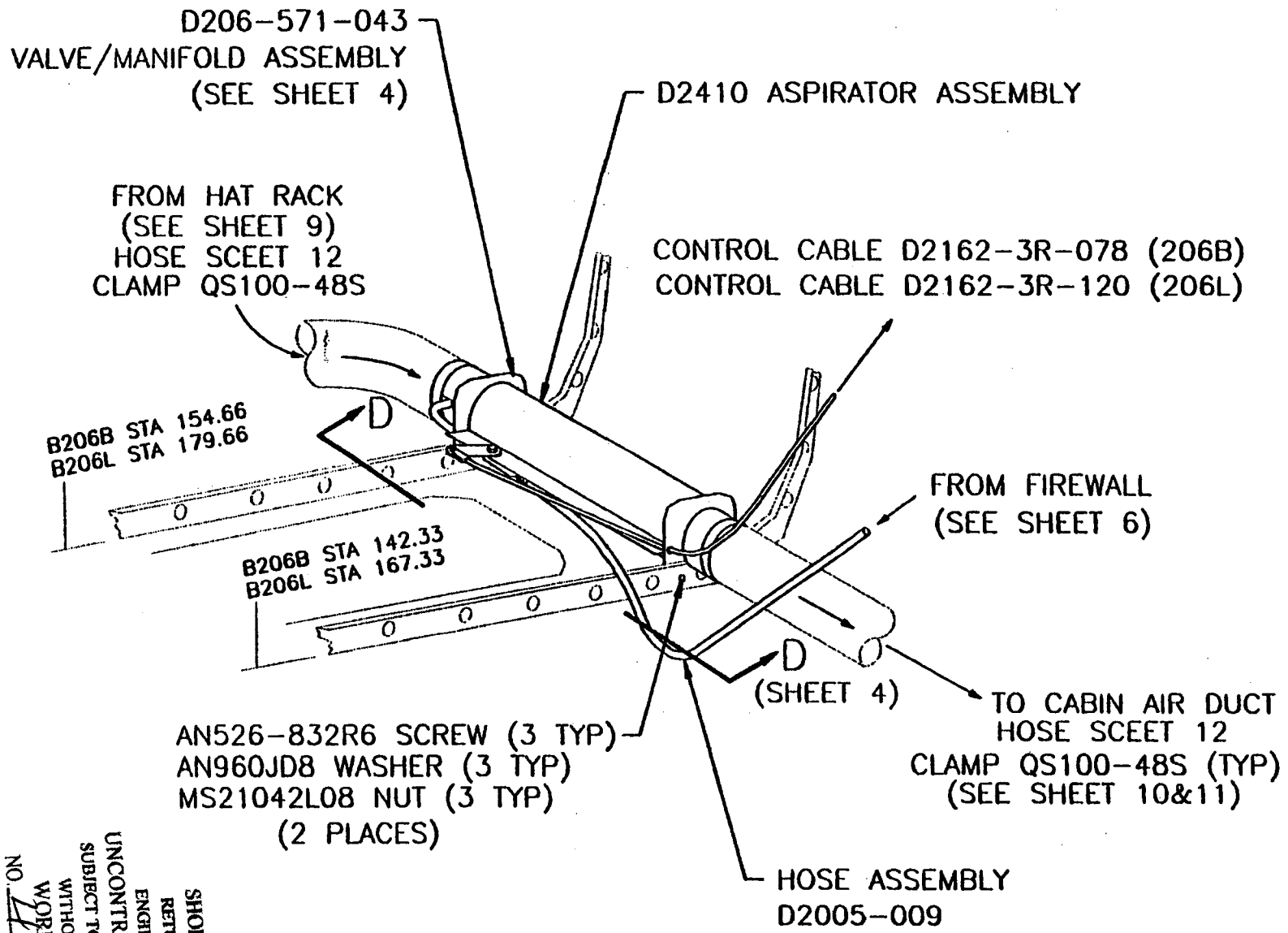
SUPPLEMENTARY HEATERS MUST BE INSTALLED IN CONJUNCTION WITH DART HEATER KIT D206-570 ie:

D206-571-341 MATES WITH D206-570-141

D206-571-345 MATES WITH D206-570-145

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**DART**



VIEW LOOKING AFT  
BEHIND HAT RACK

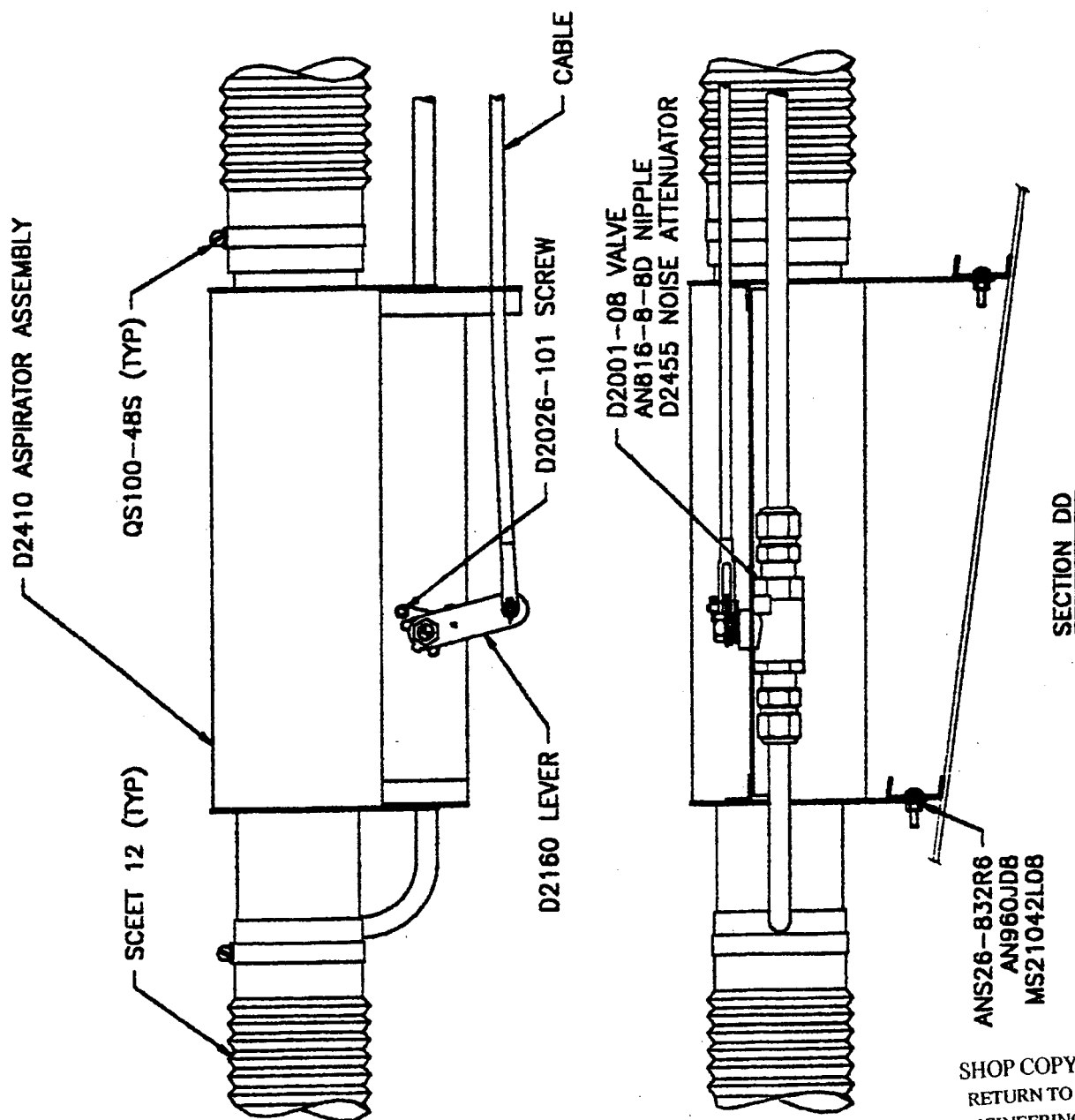
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D206-571
DATE	JUNE 9, 1992	TITLE	BELL 206 HEATING SYSTEM	REV. C SHEET 3 OF 11
C	JUNE 30, 1995	RE-DRAWN		SCALE

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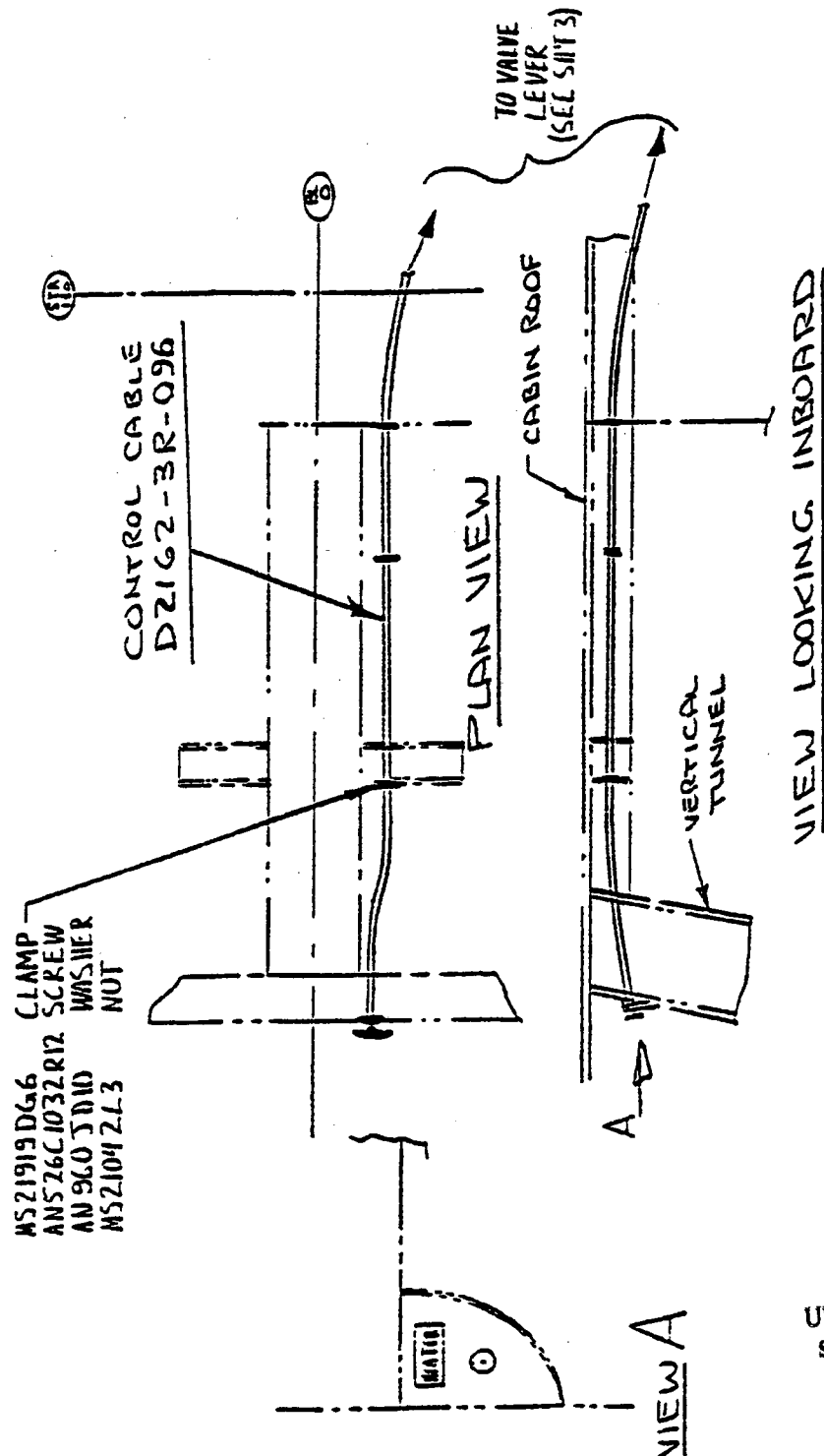
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B WILLIAMS	K HAND	DRAWING NO.	REV.C
CHECKED	APPROVED	D206-571	SHEET 4 OF 11
DATE	TITLE	SCALE	
JUNE 9, 1992	BELL 206 HEATING SYSTEM		
C	JUNE 30, 1995	RE-DRAWN	



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CHECKED <i>BW</i>	APPROVED <i>KH</i>	D206-571	SHEET 5 OF 11
DATE	TITLE	SCALE	
JUNE 9, 1992	BELL 206 HEATING SYSTEM		
C	JUNE 30, 1995	RE-DRAWN	

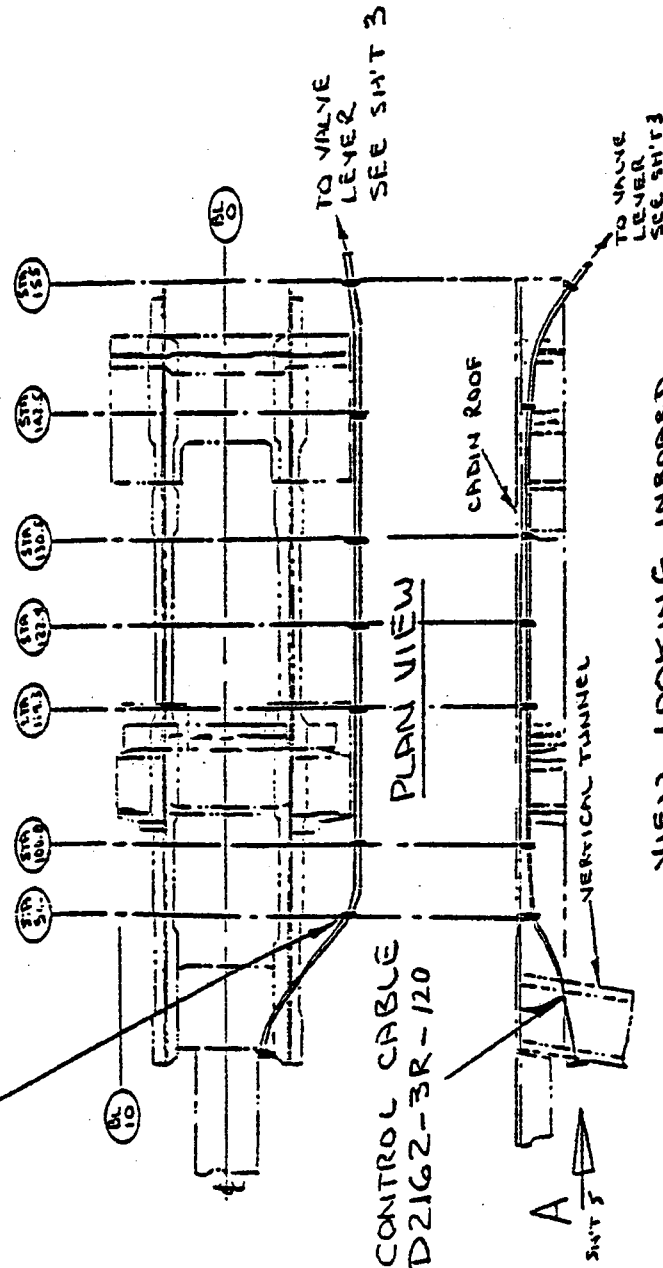


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CHECKED	APPROVED	D206-571	SHEET 6 OF 11
DATE	TITLE	SCALE	
JUNE 9, 1992	BELL 206 HEATING SYSTEM		
C	JUNE 30, 1995	RE-DRAWN	

CLAMP 118 21919 DC.6  
SPACER NAS 43 DD2-24  
SCREW AN526C102R12  
WASHER AN260 JD10  
NUT 113 21042 L03



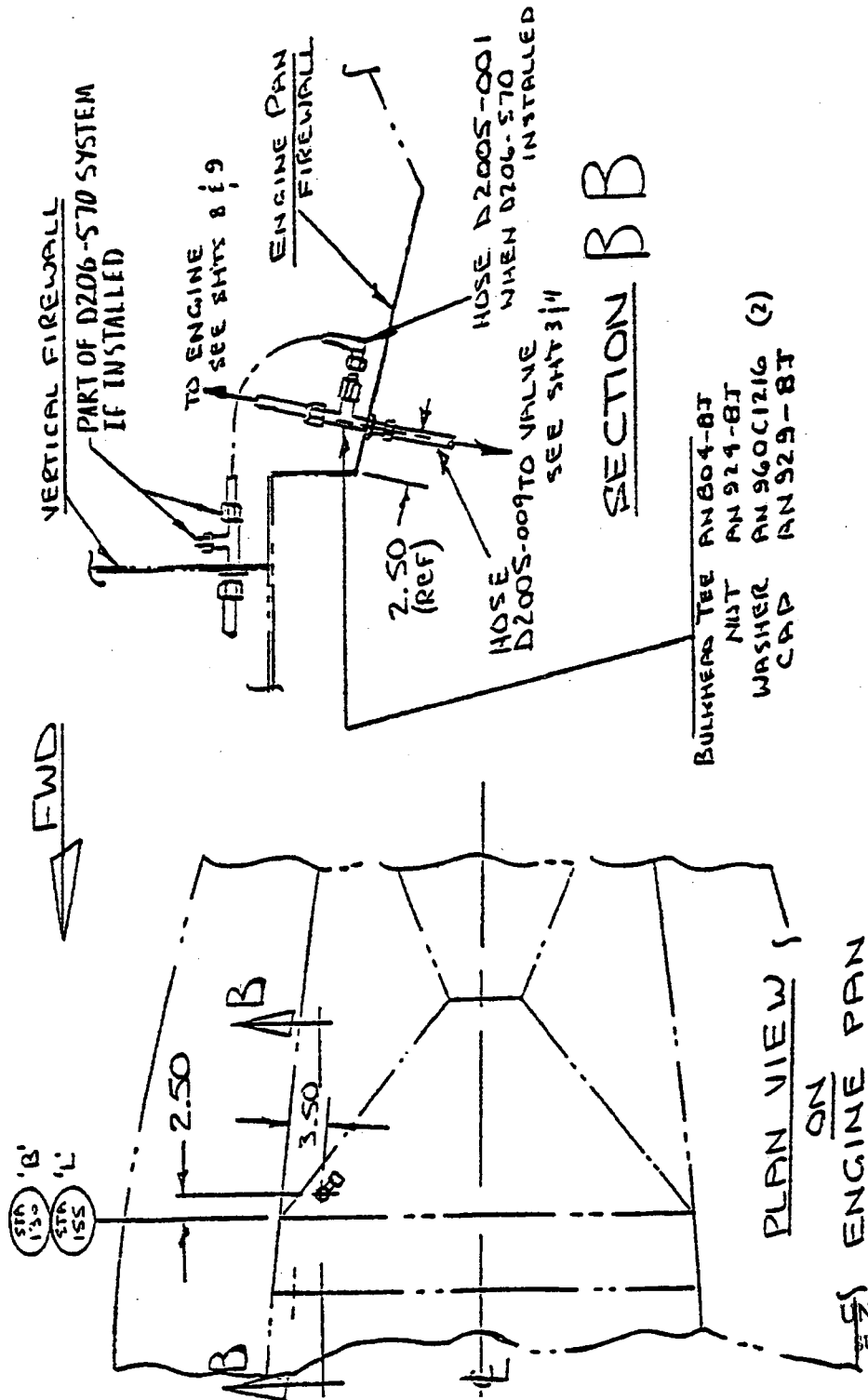
206L SERIES

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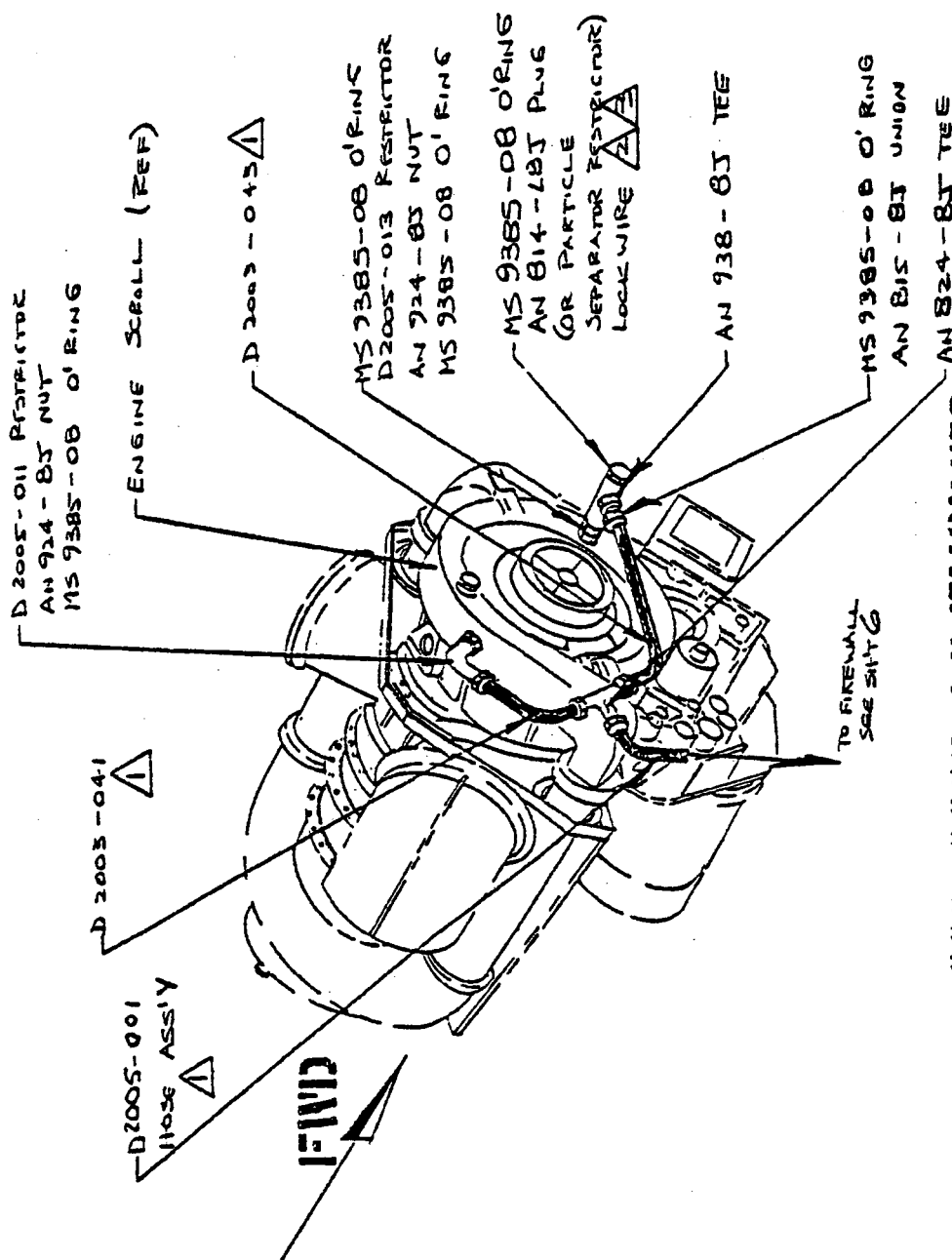
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CHECKED BW	APPROVED [Signature]	DRAWING NO. D206-571	REV. C SHEET 7 OF 11
DATE JUNE 9, 1992	TITLE BELL 206 HEATING SYSTEM		SCALE
C	JUNE 30, 1995	RE-DRAWN	



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-571	REV. C SHEET 8 OF 11
DATE JUNE 9, 1992	TITLE BELL 206 HEATING SYSTEM	SCALE	
C	JUNE 30, 1995	RE-DRAWN	

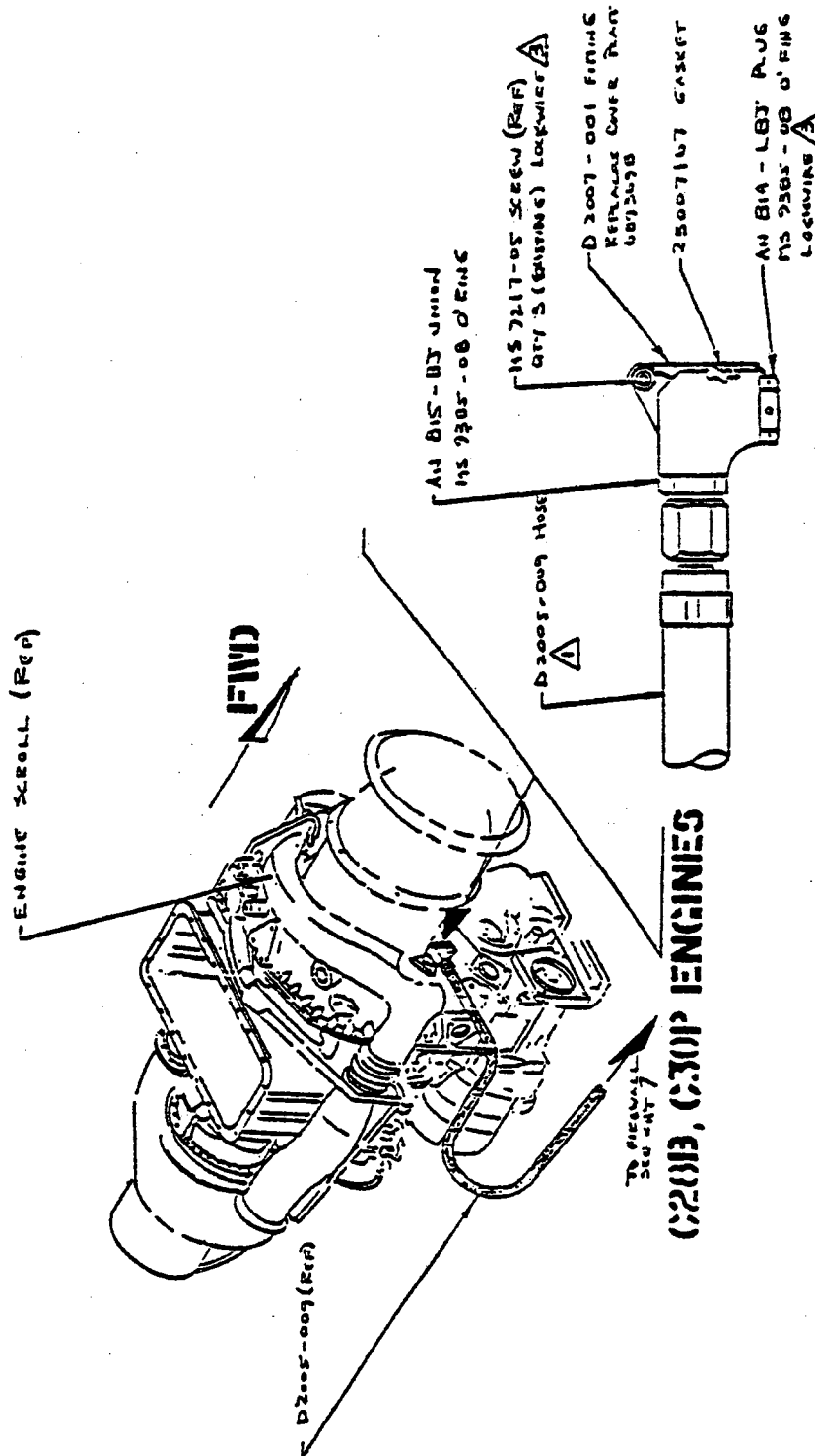


**(20, C2013, J, R ENGINES**

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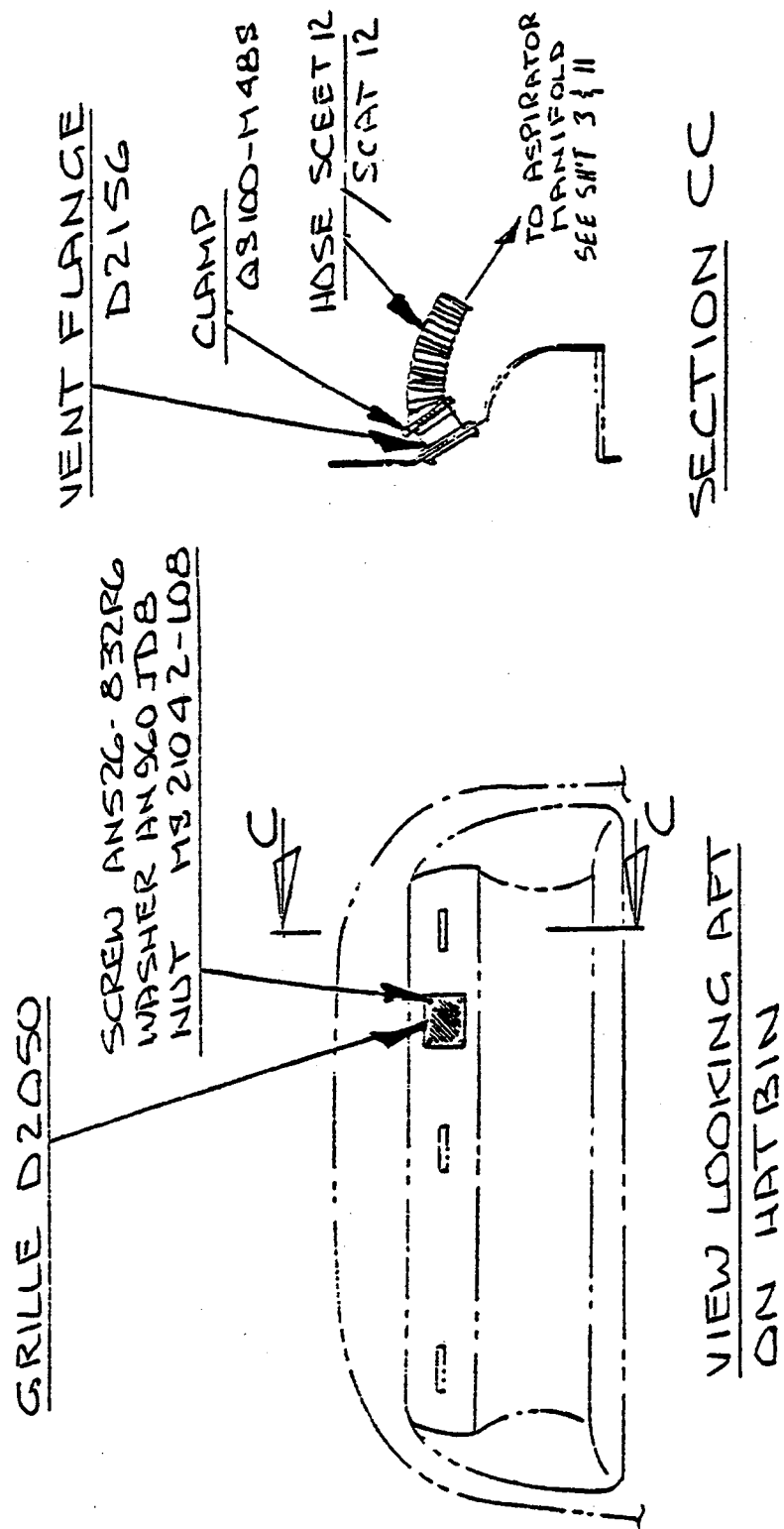
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CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D206-571	SHEET 9 OF 11
DATE		TITLE	SCALE
JUNE 9, 1992.		BELL 206 HEATING SYSTEM	
C	JUNE 30, 1995	RE-DRAWN	



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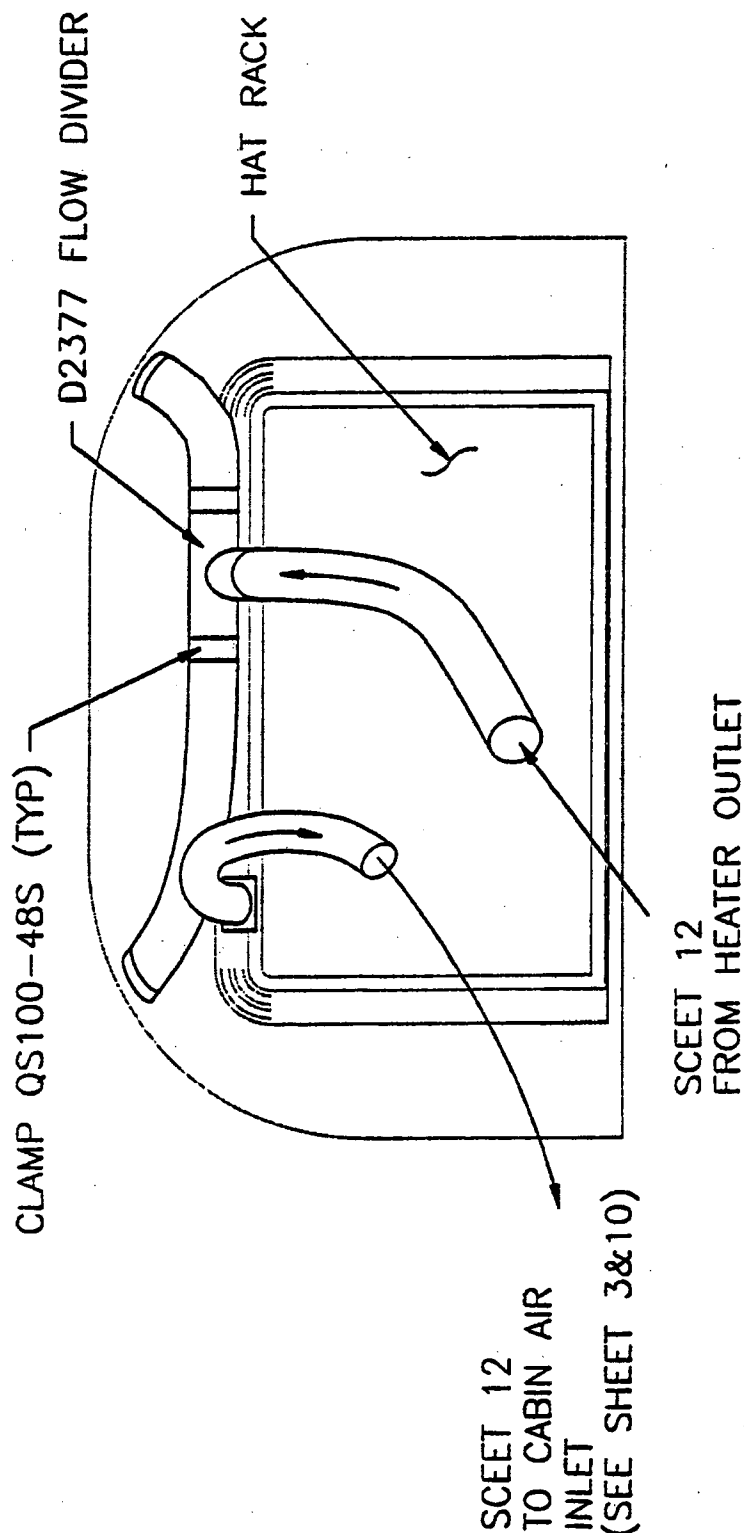
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BW	[Signature]	D206-571	SHEET 10 OF 11
DATE		TITLE	SCALE
JUNE 9, 1992		BELL 206 HEATING SYSTEM	
C	JUNE 30, 1995	RE-DRAWN	



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B WILLIAMS	K HAND	DRAWING NO.	REV. C
CHECKED	APPROVED	D206-571	SHEET 11 OF 11
DATE	TITLE	SCALE	
JUNE 9, 1992	BELL 206 HEATING SYSTEM		
C	JUNE 30, 1995	RE-DRAWN	



VIEW LOOKING FORWARD,  
AFT OF HAT RACK

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